




Date: Tuesday, 16/09/2008 2:38:37 PM  
User: Linda Lapelle

SPLIT-

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 DETAIL PARTS
Job Number	: 42032 ~ 1		
Estimate Number	: 13228		
P.O. Number	:	Part Number	: 02127251935
This Issue	: 16/09/2008 S.O. No. :	Drawing Number	: 0212-725-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/09/2008 Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 40129	Material	: N/A
Written By	: 	Due Date	: 26/09/2008 Qty:  Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A 08-09-16 New Issue LL		

### Additional Product

# PRELIMINARY ISSUE

Job Number:  PRELIMINARY ISSUE

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING  
Issue P/O: 7167 to Cimtube Itex  
Make per drwg D212-725-1 Rev. E  
ship to supplier:

C208/09/14

(S)

POSITIVE  
RECALL

1 x AN818-BJ nut B m107959 K5  
1 x MS20819-8J sleeve B m107959 K5

20 AN8188J Nut

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
Nut m 107950 x 5 C208104/15



3.0 MS208198J Sleeve

Comment Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Sleeve

110795915 C20810415

4.0 D2127251935 tube

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Date: Tuesday, 16/09/2008 2:38:37 PM  
 User: Linda Lacelle

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 DETAIL PARTS

Job Number: 42032

Part Number: D2127251935

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR  
 TRANSIT DAMAGE  
 ENSURE C OF C ATTACHED

08/10/20

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT LEVEL 5

RF 08.10.28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Identify with P/N and B/N using a fine point marker

Location:

RF 08.10.28

08/10/20

RF 08.10.28

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/20 AUTH

RELEASED

DATE

08/10/29

Date: Tuesday, 16/09/2008 2:38:37 PM  
 User: Linda Lacelle

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 DETAIL PARTS  
 Job Number : 42032 ~ 1  
 Estimate Number : 13228  
 P.O. Number :  
 This Issue : 16/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2127251935  
 First Issue : 16/09/2008 Type : PURCHASED PARTS Drawing Number : D212-725-1 REV E  
 Previous Run : 40129 Project Number : N/A  
 Material : N/A  
 Due Date : 26/09/2008 Qty: 5 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 08-09-16 New Issue LL

## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 7167 to Cimtube ltee  
 Make per drwg D212-725-1 Rev. E

C208109/14 (S)



ship to supplier:

1 x AN818-8J nut B m107959 x5  
 1 x MS20819-8J sleeve B m107959 x5

2.0 AN8188J Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Nut m107950 x5 C208109/15

3.0 MS208198J Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Sleeve m107959 x5 C208109/15

4.0 D2127251935 tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 16/09/2008 2:38:37 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 DETAIL PARTS

Job Number: 42032

Part Number: D2127251935

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR  
TRANSIT DAMAGE  
ENSURE C OF C ATTACHED

C208110/20

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT LEVEL 5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Identify with P/N and B/N using a fine point marker  
Location: \_\_\_\_\_

C208110/20 ①

send to Roberto 08/10/20 KD fedex



8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/20 AUTH [Signature]

RELEASED [Signature]

DATE 08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

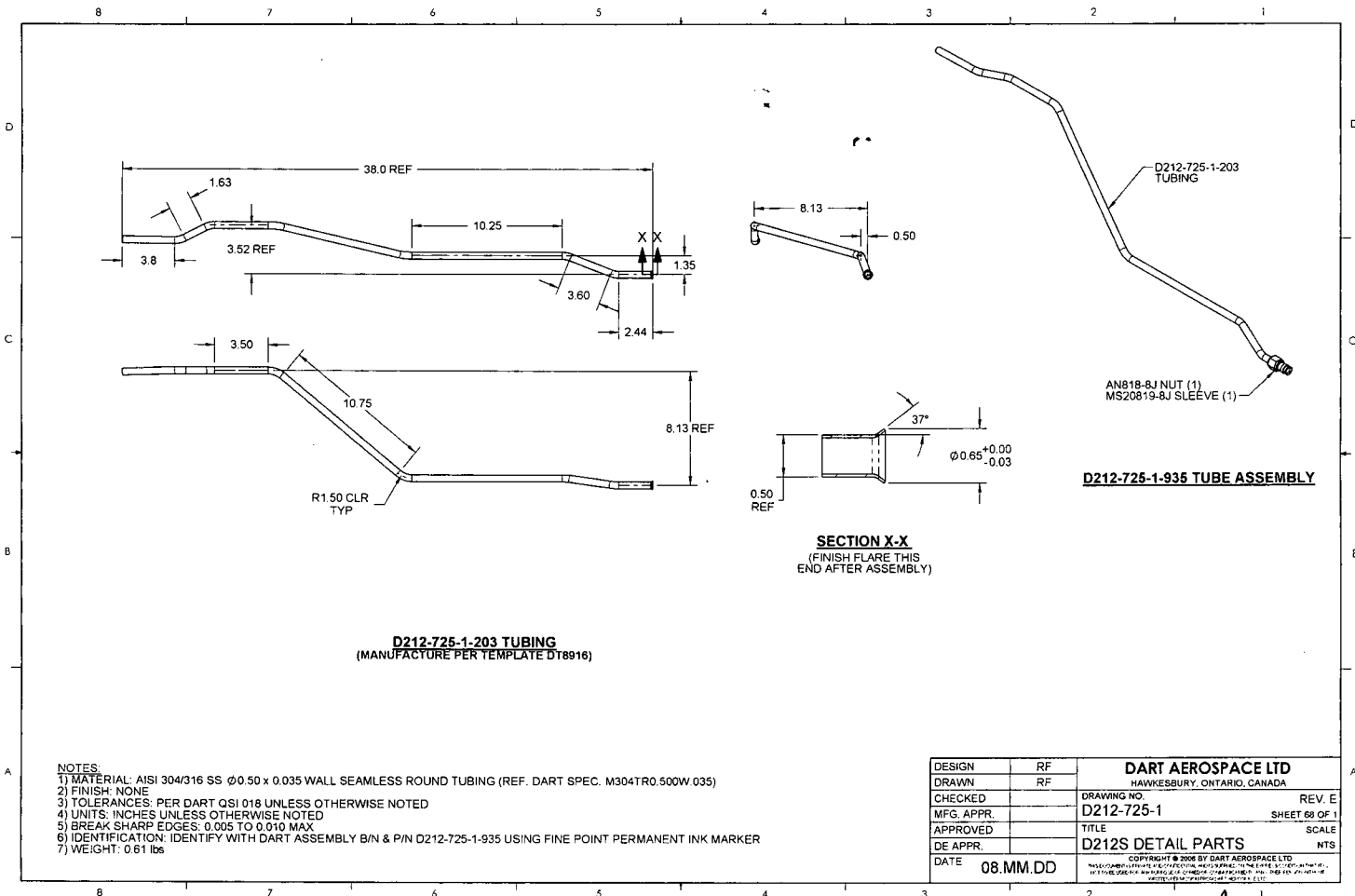
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

568



42032

CLIENT: Page 1 of 1  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.

HAWKSBURY  
ON K6A 1K7  
EXPED. ATO:  
SAME

M-100435

**CINTUBE** LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 10 ☐ 1250 MATHESON BLVD. EAS  
LACHINE, QUEBEC MISSISSAUGA, ONTARIO  
H8S 2K9 L4W 1R2  
TEL: (514) 634-3592 TEL: (905) 625-1900  
FAX: (514) 636-3336 / 8625 FAX: (905) 625-1500

Rep: JASON ROBINSON

CINTUBE

BON. LIVR	RELACHE
PACK. SLIP	RELEASE

M-100435

DATE: 16-Sep-08  
COMMANDE #: 7167  
ORDER #:

CONTACT PHONE #: (613) 632-9577 EXT. #:  
FAX #: (613) 632-1053

CLIENT NO. MDAR72	MAT'L PAR / MAT'L BY CINTUBE & CLIENT	REFERENCE
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TRANSPORT  
PUROLATOR COLLECT #7684382

DATE LIV. / DELIV. DATE  
1 ATO 2 SEM./WKS

CONTACT  
CHANTAL LAVOIE

QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
5	1	0.625 OD	0.035	PART NO. DART D212-725-1 S73 SMLS TUBE SS/304L ✓	8 BENDS		SEE DRWG: D212-725-1 S73	FINAL CUT & FLARE ONE END
5	1	0.5 OD	0.035	PART NO. DART D212-725-1 S68 SMLS TUBE SS/304L ✓ <i>CL 08/10/20</i>	6 BENDS		SEE DRWG: D212-725-1 S68	FINAL CUT & FLARE ONE END
2	2			TWO COPIES OF MILL TEST REPORTS				
2	1			TWO COPIES OF LETTER OF COMPLIANCE				

QIC

SENT WITH SHIPMENT *Oct. 17/08*

Notes:

CATEGORIE ISO  
ISO CATEGORY

1 2 3  
☐ ☐ ☒

ASME

EXPEDIE PAR / SHIPPED BY

DATE CLIENT AVIS. / ADV.:

*Yves P.*

CERTIFICAT D'ANALYSE  
MILL. TEST CERTIFICATE

OUI  
YES ☒

LETTRE DE CONFORMITE  
LETTER OF COMPLIANCE

OUI  
YES ☒

CONTACT:

DATE: *Oct 17/08*

CLIENT:

PAR/BY:

DATE:



# CINTUBE

LYEE  
LTD.

CONTRACT DE PRÉCISION DE TUBES, TUYAUX, CORBÈRES, POUTRES,  
PROFILÉS EN "U" ET SÉPENTINS  
MANUFACTURER OF GENERATORS, ELEMENT CHAUFFANT,  
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISSEUR ETC  
PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS,  
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,  
WASTE HEAT RECOVERY UNITS, ECONOMIZERS

333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H6S 2J1  
TÉLÉPHONE: (514) 364-6426 FAX NO. (514) 368-1313

## LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD Date: OCT. 17/08

N° de commande du client/Customer order No: 7167

Notre n° de feuille de route/Our order No: 100435

Notre n° de dessin/Our drawing No: —


Description/Customer drawing No: D212-725-1 S68, D212-725-1 S75

Nom de la pièce/Part Name: P/N D212-725-1-203, P/N D212-725-1-213

ONE PIECE OF EACH

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by: 

G. HOULE pour B. GUERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltee/On behalf of Cintube Ltd.

F 10.4.3



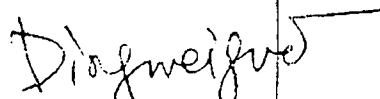
# CPI INDUSTRIES CO., LTD

## MILL TEST REPORTS

ISO9001:2000 ; PED CERTIFICATE ( Certificate No.: QAC0021058/A )

DATE OF ISSUE: 2006/4/28

CINTUBE LTD.  
 order number: 100435  
 order contract no.  
 customer: DART AEROSPACE  
 order date: 3167  
 order price  
 date: 05.17.08

CUSTOMER: NORCA						CERTIFICATE NO.: 2006-3-8-2						
P.O. NO.: 32355						ORDER NO.: 2006-3-008						
COMMODITY: STAINLESS STEEL SEAMLESS TUBING.						GRADE: ASTM A213-04b TP304/TP304L						
CONDITION: COLD FINISH / SOLUTION TREATED / PICKLED / PLAIN END / OD POLISHED 240 GRIT.						HEAT NO.: 572-2517						
CHEMICAL CONTENTS (WT%)												
ELEMENTS		C	Mn	P	S	Si	Ni	Cr				
SPECIFICATION		≤ 0.035	≤ 2.00	≤ 0.045	≤ 0.030	≤ 1.00	8.0~12.0	18.0~20.0				
RESULTS (PRODUCT)		0.025	1.21	0.032	0.008	0.33	8.38	18.64				
PHYSICAL PROPERTIES												
Dimensions			Bundle No.	Pieces	Weight (kg)	0.2%YS (Mpa) ≥ 205	T S (Mpa) ≥ 515	EL (%) ≥ 35	FLARING TEST	FLATTENING TEST	HARDNESS HRB ≤ 80	EDDY CURRENT TEST (100%)
O.D (inch)	W.T (inch)	Length (feet)										
3/8	0.065	20	06-3-8-5	150	296	250	605	68.5	OK	OK	65	OK
1/2	0.035	20	06-3-8-6	1250	1993	300	675	62.0	OK	OK	72	OK
1/2	0.049	20	06-3-8-7	750	1624	270	625	62.5	OK	OK	67	OK
1/2	0.065	20	06-3-8-8	500	1385	245	610	67.0	OK	OK	64	OK
REMARKS: AS PER ASTM A213/ASME SA213-04b WALL THICKNESS TOLERANCE AS PER ASTM A269-04 IN COMPLIANCE TO NACE MR0175-2002 IC TEST TO ASTM A262 PRACTICE E SOLUTION HEAT TREATMENT : 1050°C X 1.5m/min. NO WELD REPAIR WAS PERFORMED FREE FROM MERCURY CONTAMINATION FREE OF RADIATION CONTAMINATION MEASUREMENT & SURFACE: OK CONFORMANCE TO NACE AND EN 10204-3.1B UNS S30400/30403						1. WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND THE TEST RESULTS ARE IN COMPLIANCE WITH THE TERMS OF THE PURCHASE ORDER OR CONTRACT 2. THE CERTIFICATE SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.						
						CPI INDUSTRIES CO., LTD  MANAGER OF QUALITY ASSURANCE DEPARTMENT						

**L Lacelle**

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**From:** Roberto Fuentes [rfuentes@dartaero.com]  
**Sent:** October 28, 2008 8:55 AM  
**To:** 'L Lacelle'  
**Subject:** RE: tubes

There all 3 tubes are ok. I will send to you today template and the previous w/o. I will call you in few minutes.

Roberto

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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Tuesday, October 28, 2008 5:34 AM  
**To:** 'Roberto Fuentes'  
**Subject:** tubes

Hi Roberto,  
Any news on the tubes???

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd